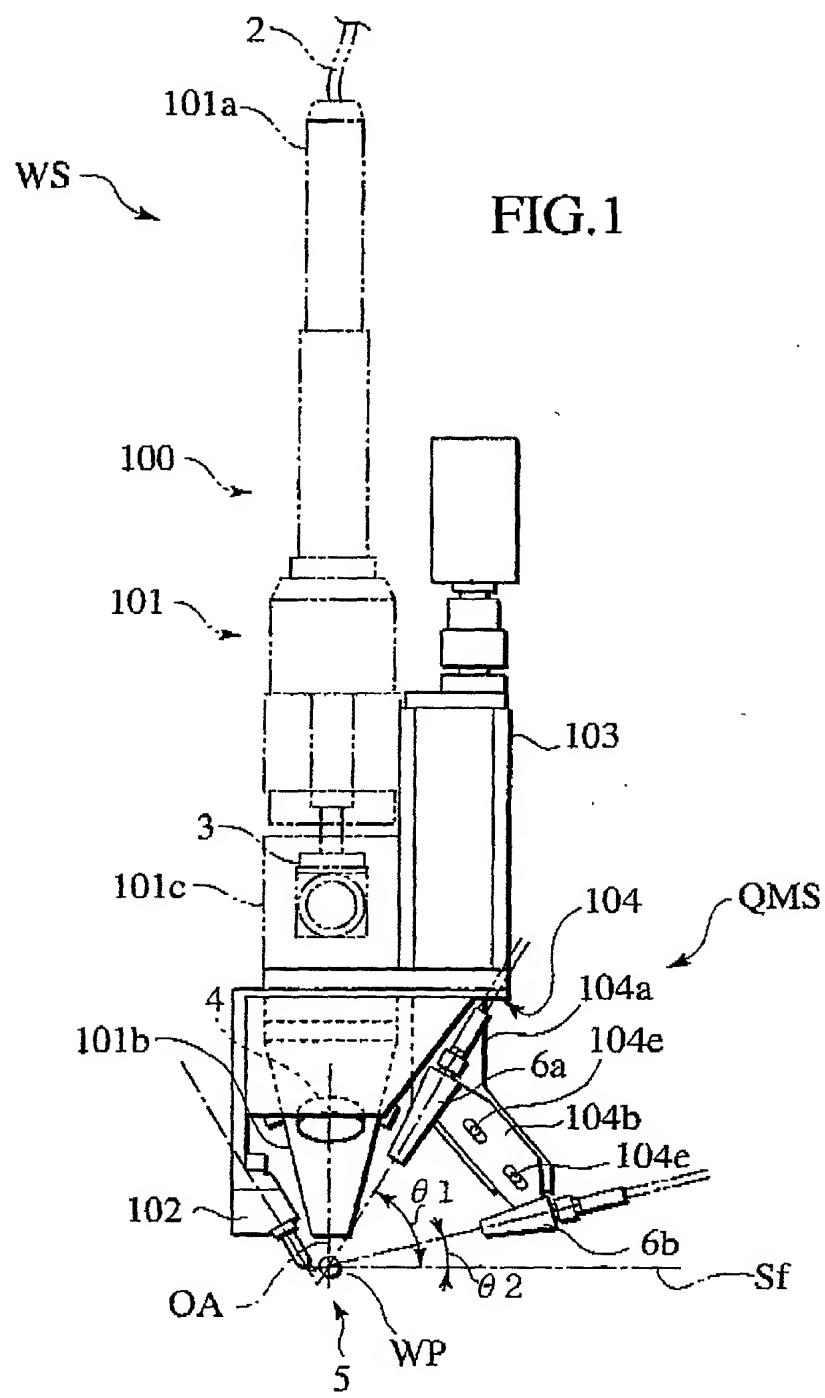


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FIG.2

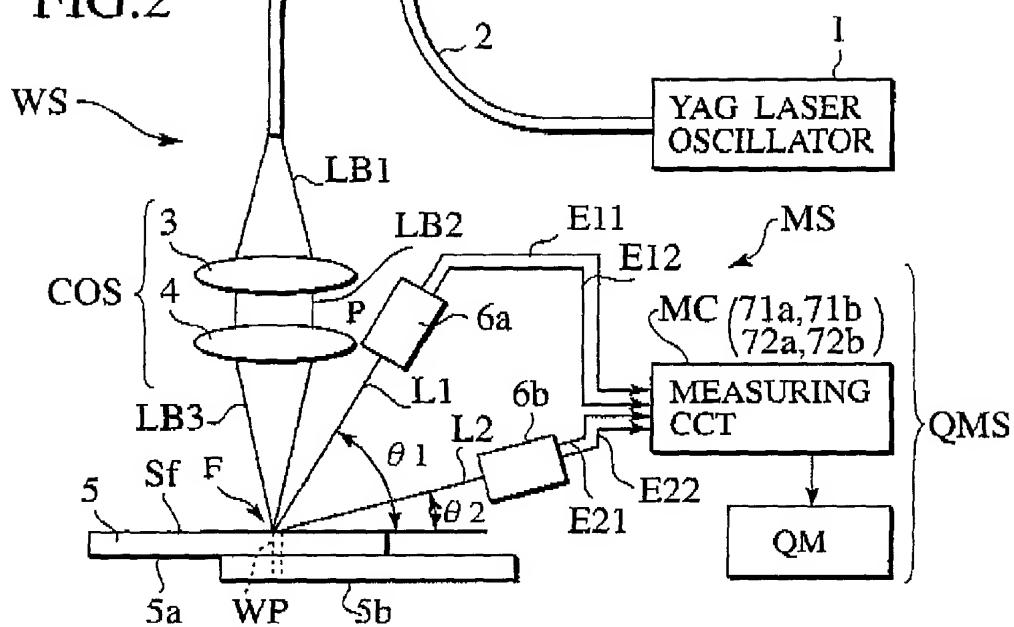


FIG.3

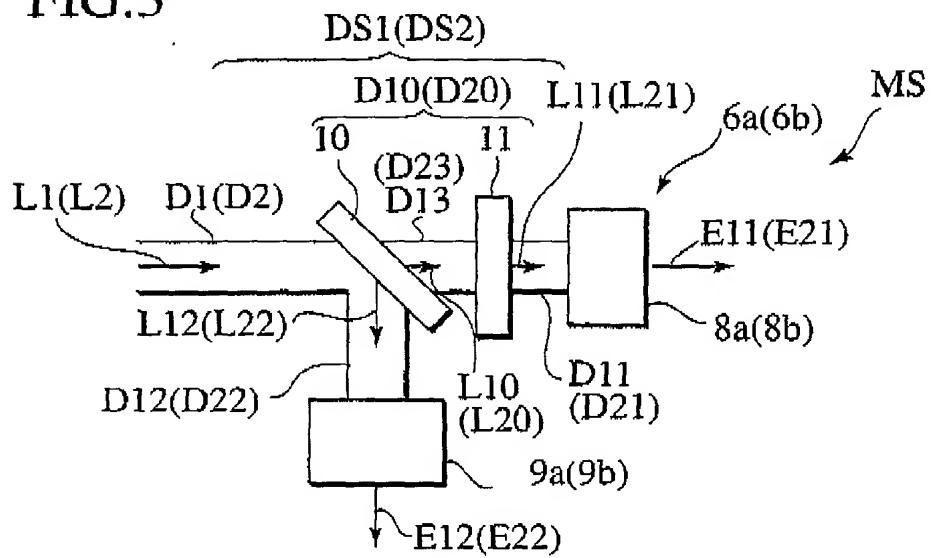
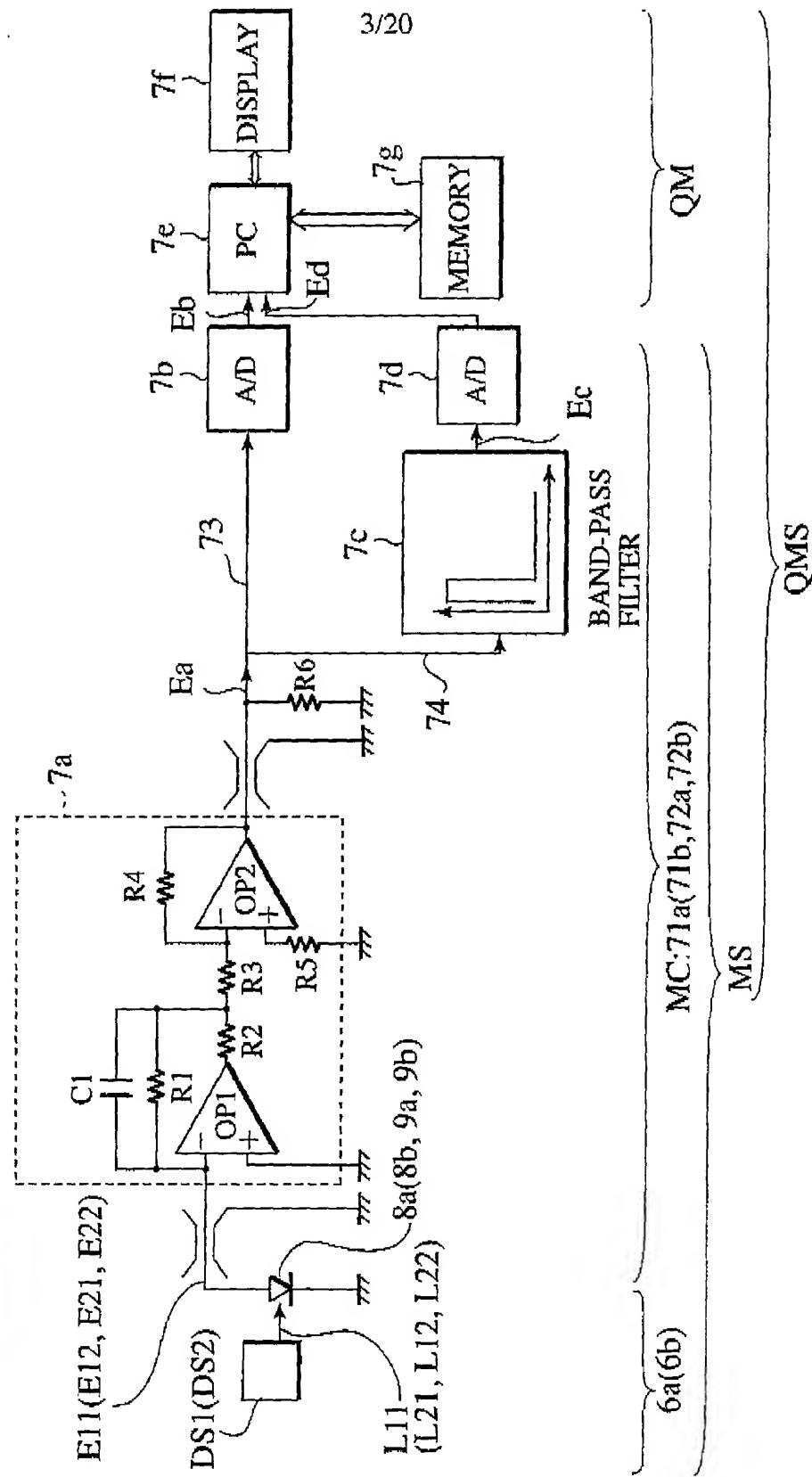


FIG.4
PL:PL1a(PL1b,PL2aPL2b)



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FIG.5

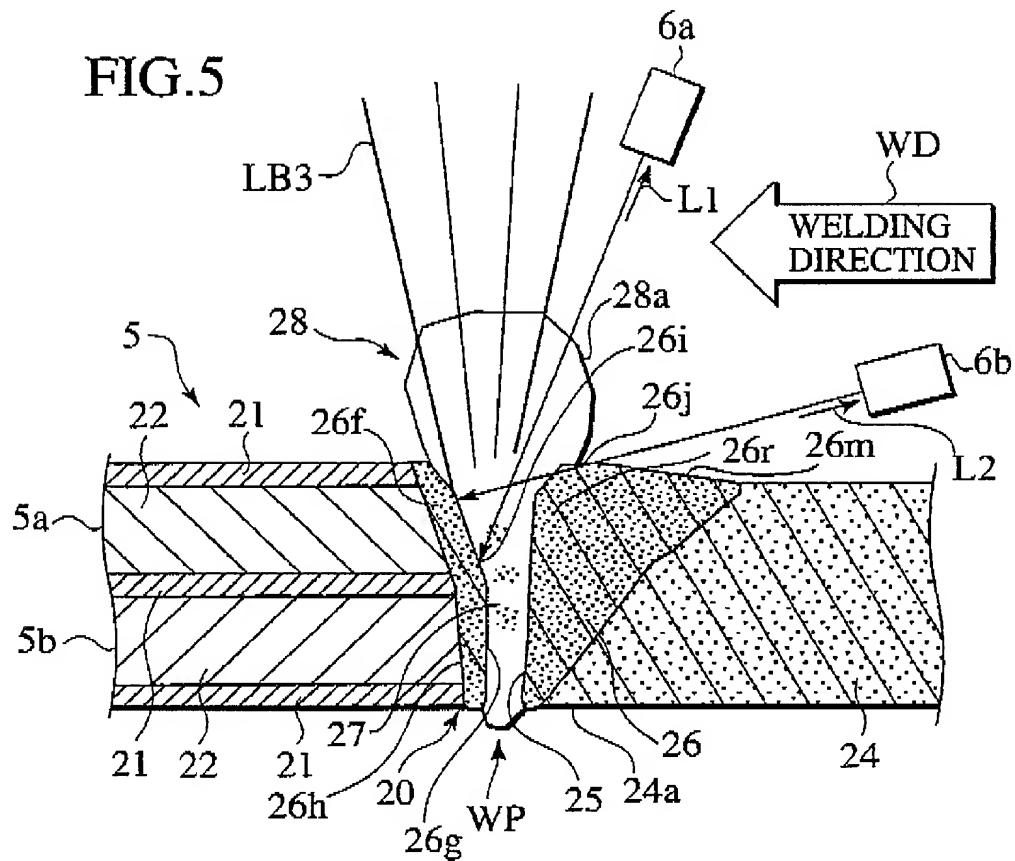
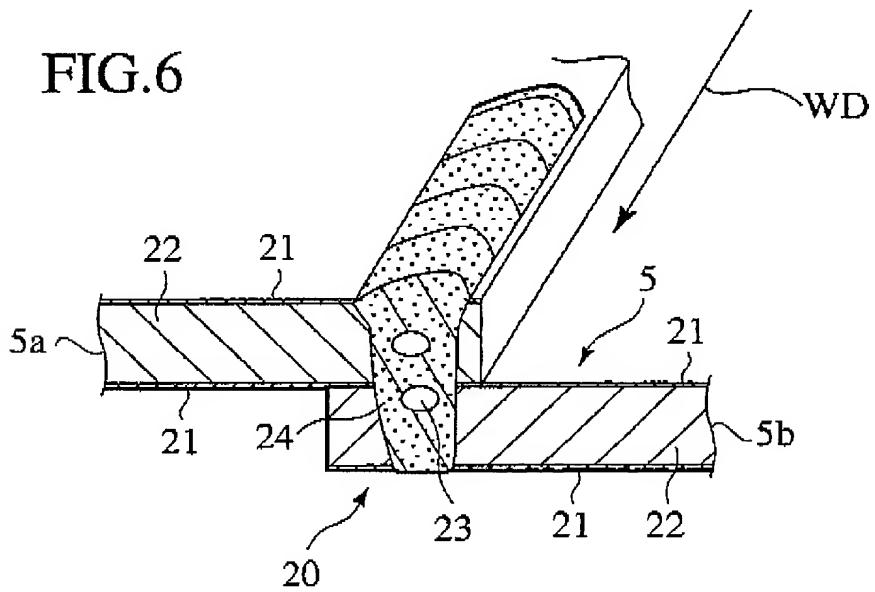
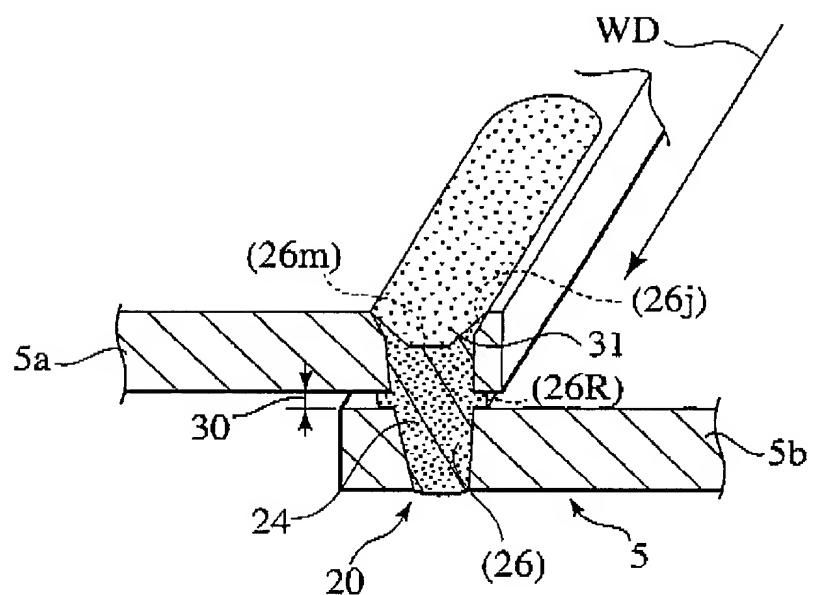


FIG. 6



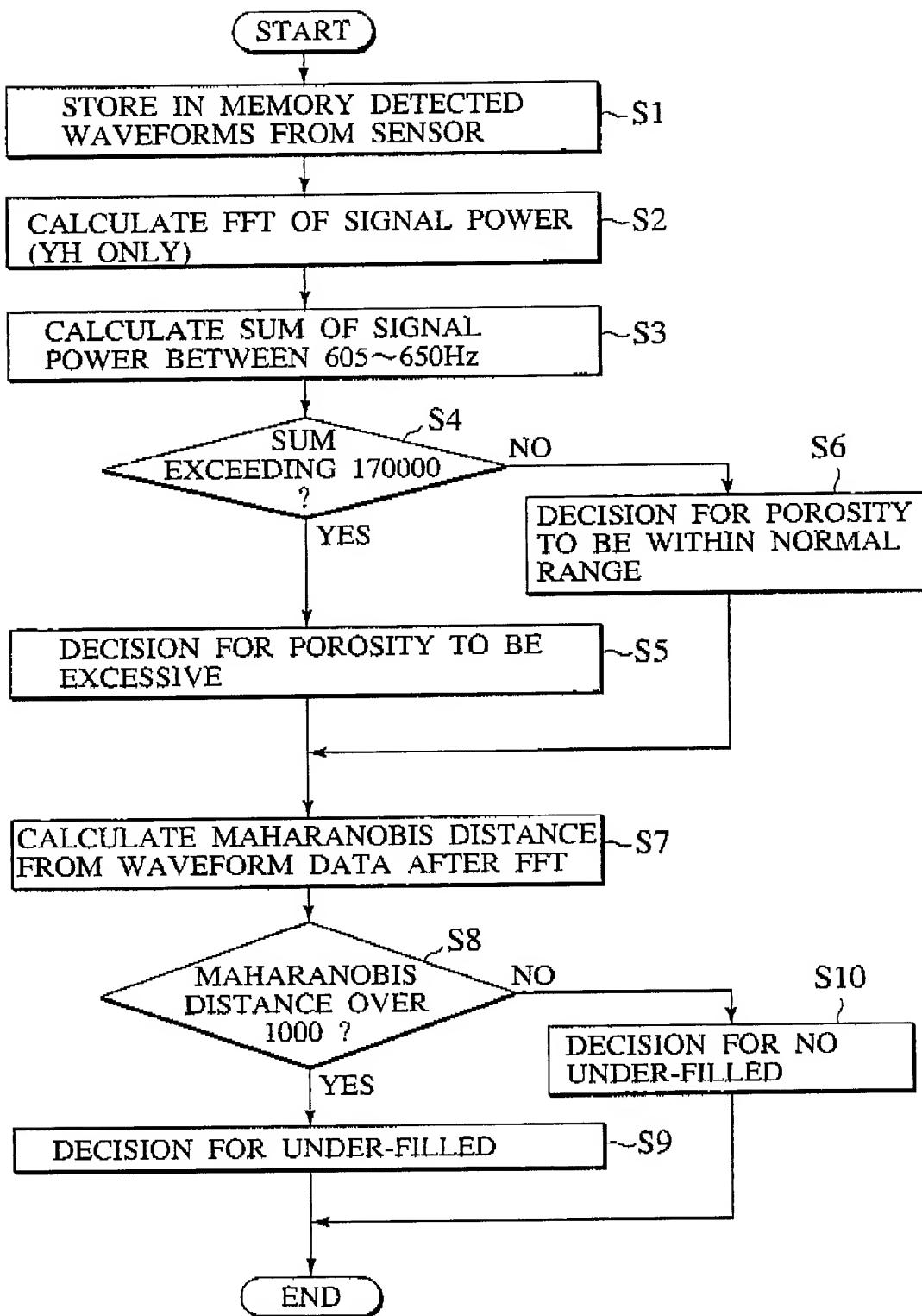
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FIG.7



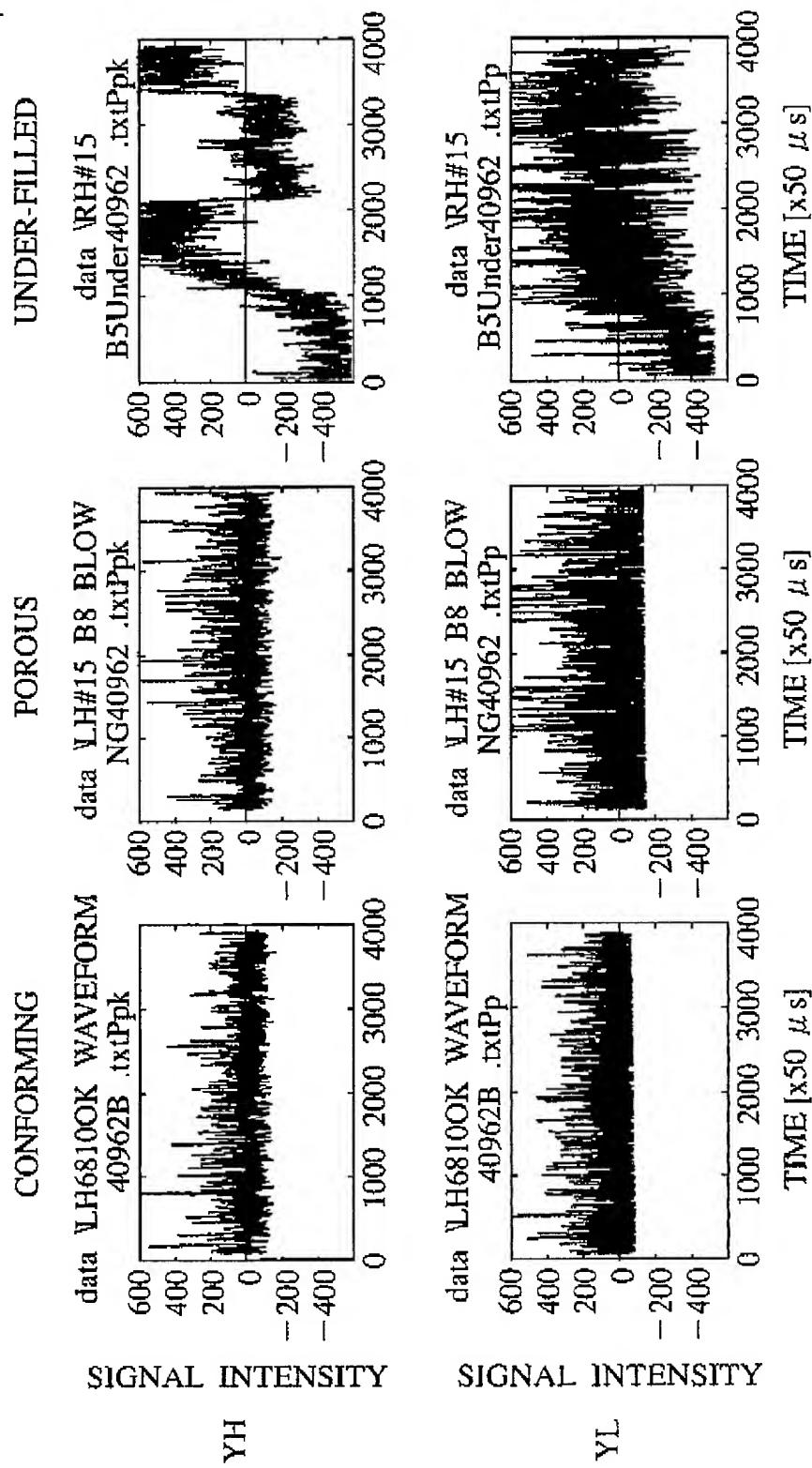
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FIG.8



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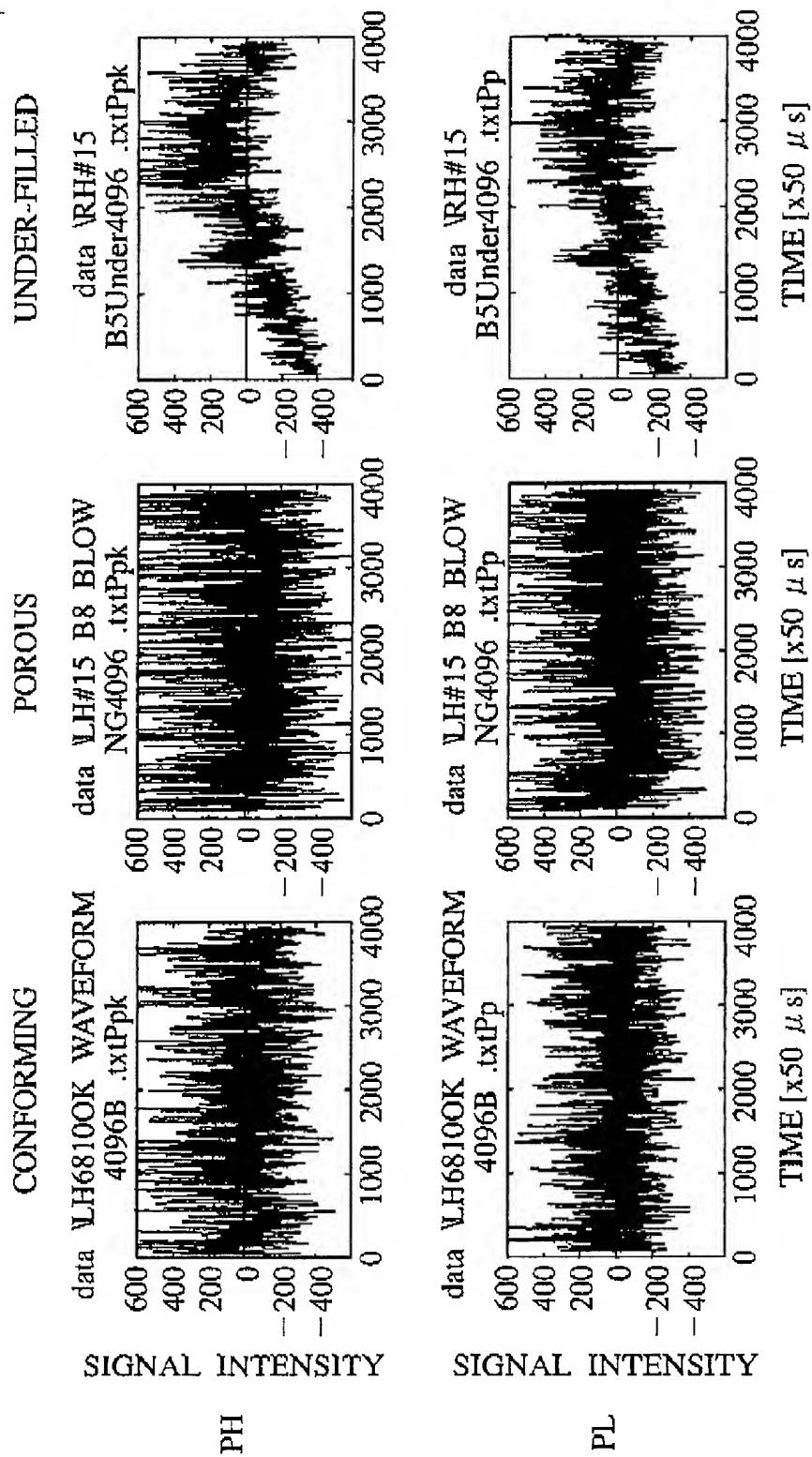
FIG.9



DETECTED WAVEFORMS UNDER BASIC WELDING CONDITIONS

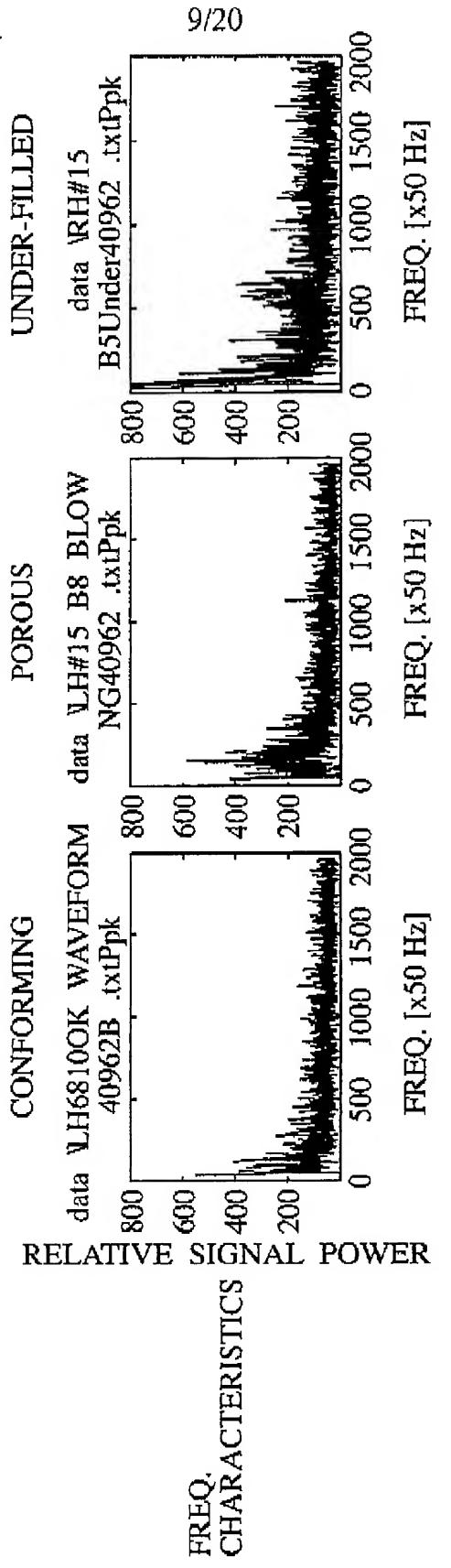
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FIG.10



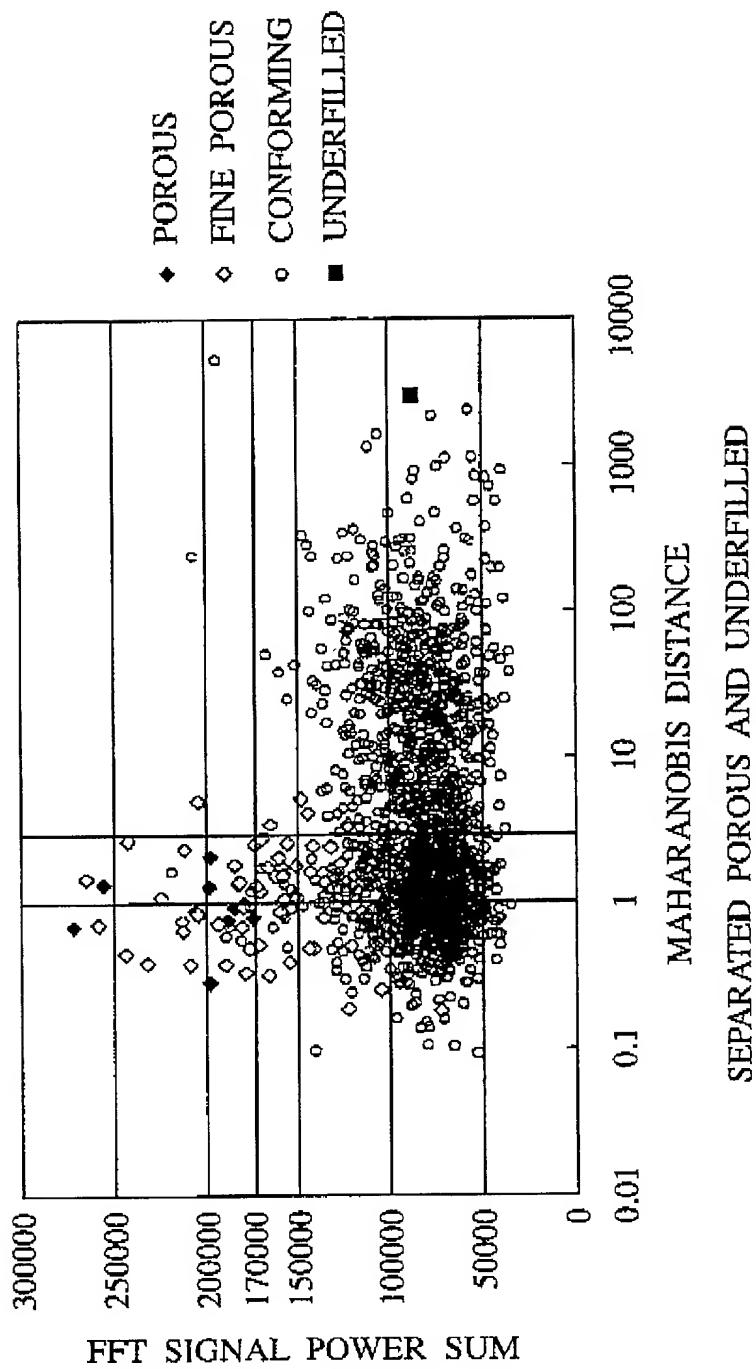
DETECTED WAVEFORMS UNDER BASIC WELDING CONDITIONS

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FIG.12



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FIG.13

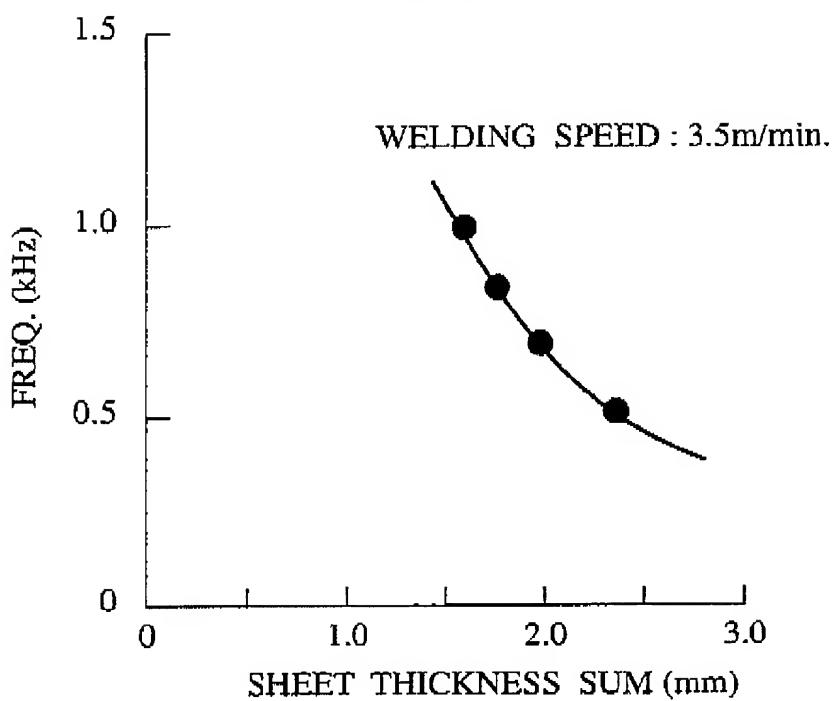
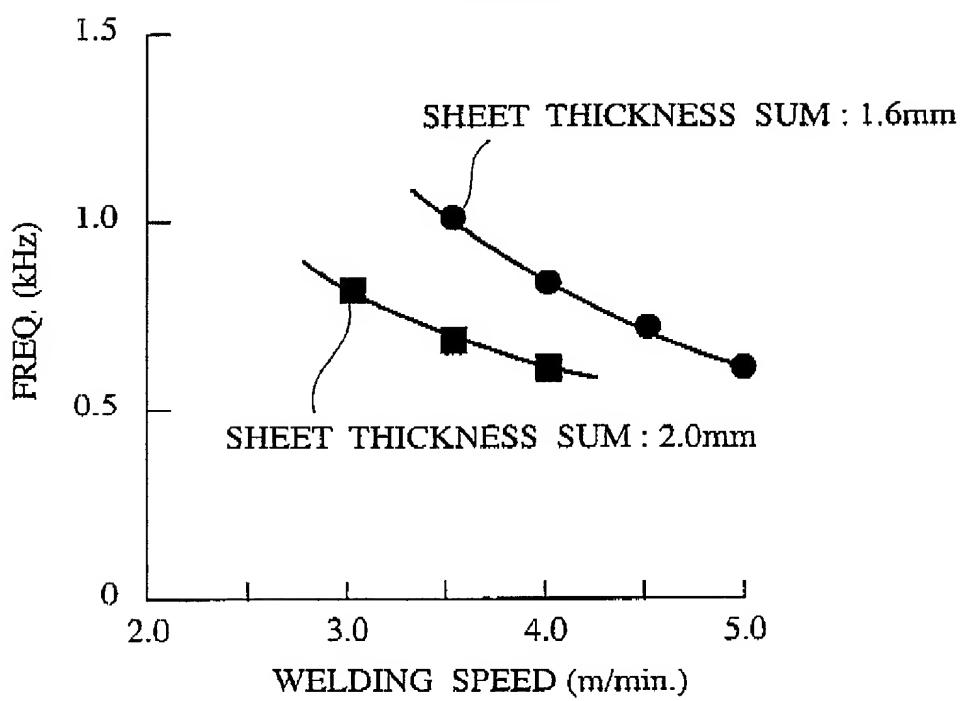


FIG.14



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FIG.15

TABLE-1

		UPPER SHEET t_1		
LOWER/UPPER		0.8mm	1.0mm	1.2mm
LOWER SHEET t_2	0.8mm	3.5m/min.	3.5m/min.	3.5m/min.
	"	4.0m/min.		
	"	4.5m/min.		
	"	5.0m/min.		
	1.0mm	3.5m/min.		
	1.2mm	3.0m/min.		
	"	3.5m/min.		3.5m/min.
	"	4.0m/min.		

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FIG.16

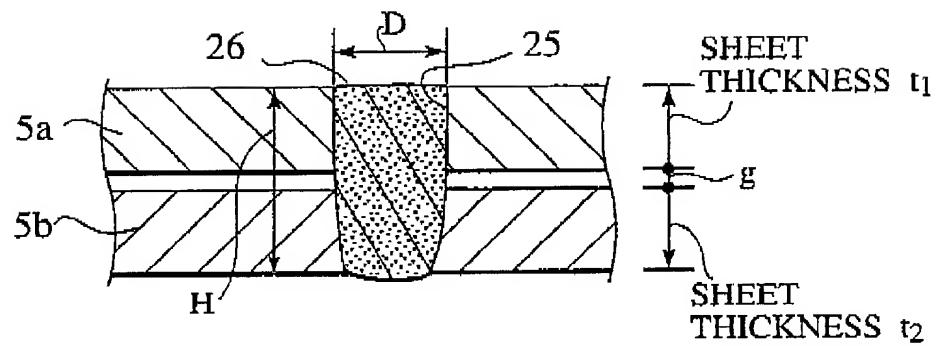
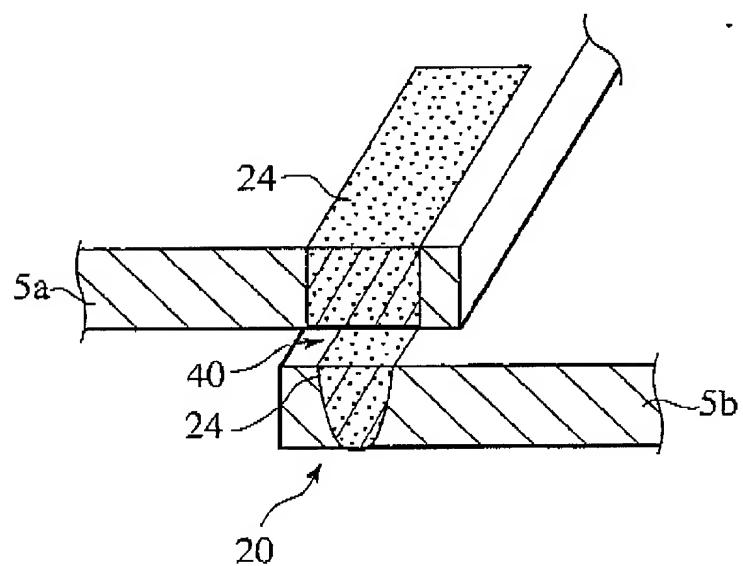


FIG.17



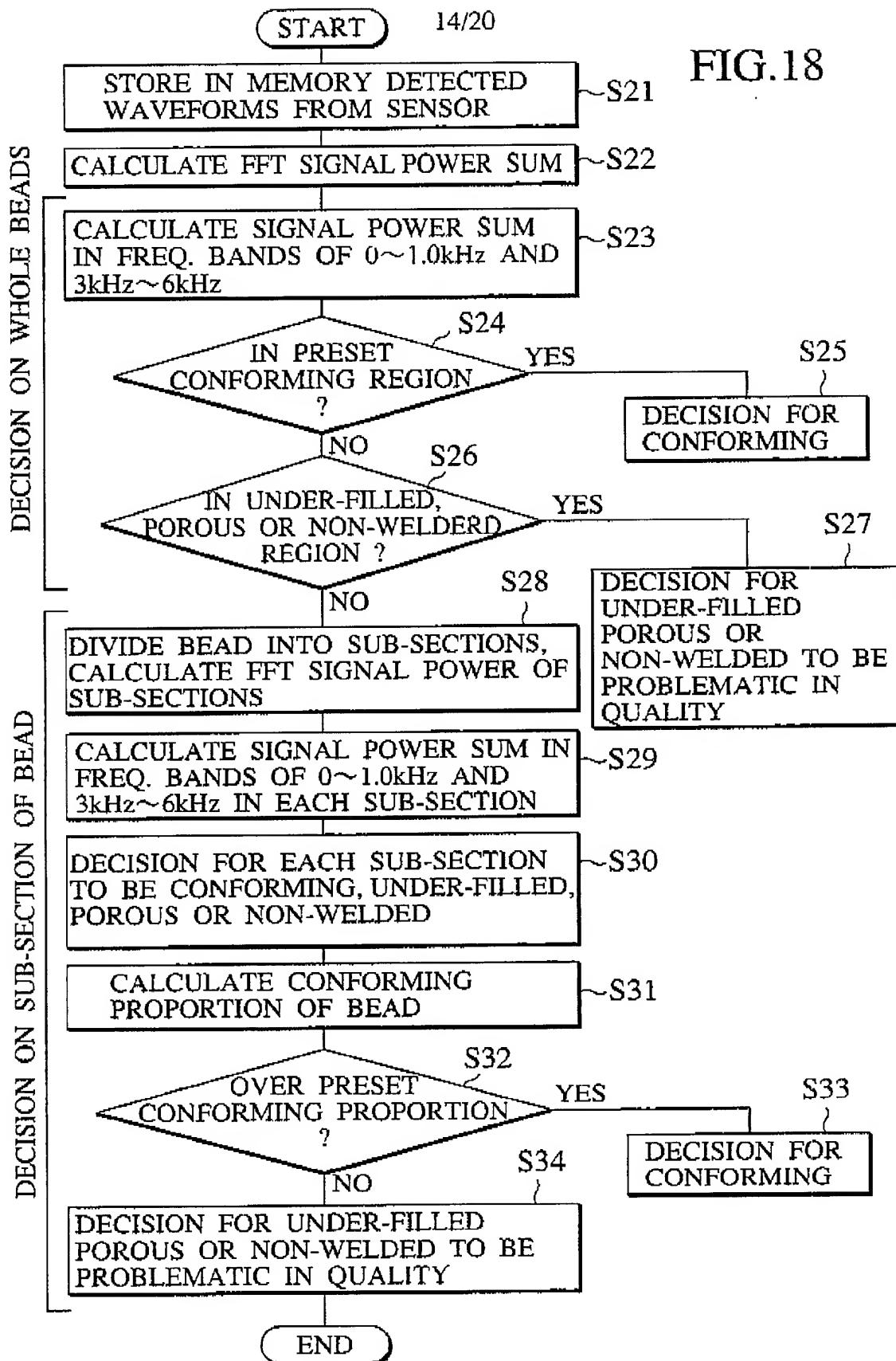


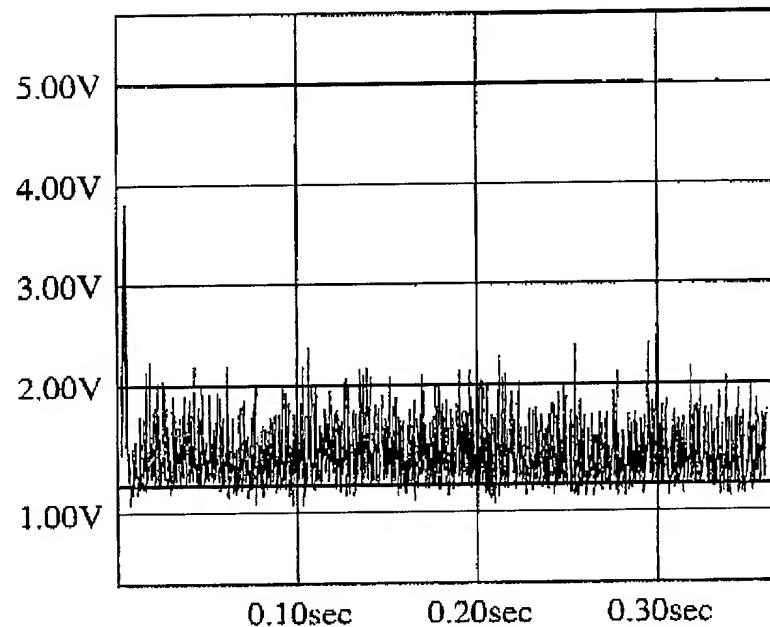
FIG.18

2025cbe8eef35ff3cf7d

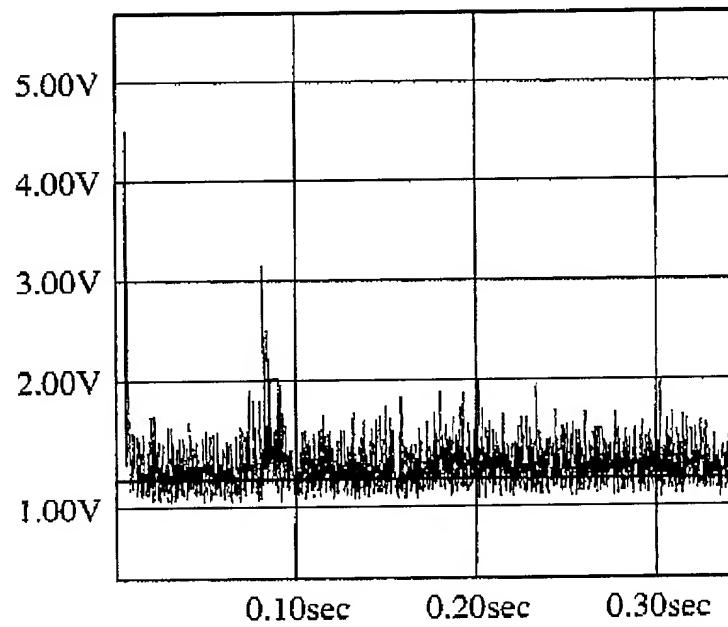
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FIG.19

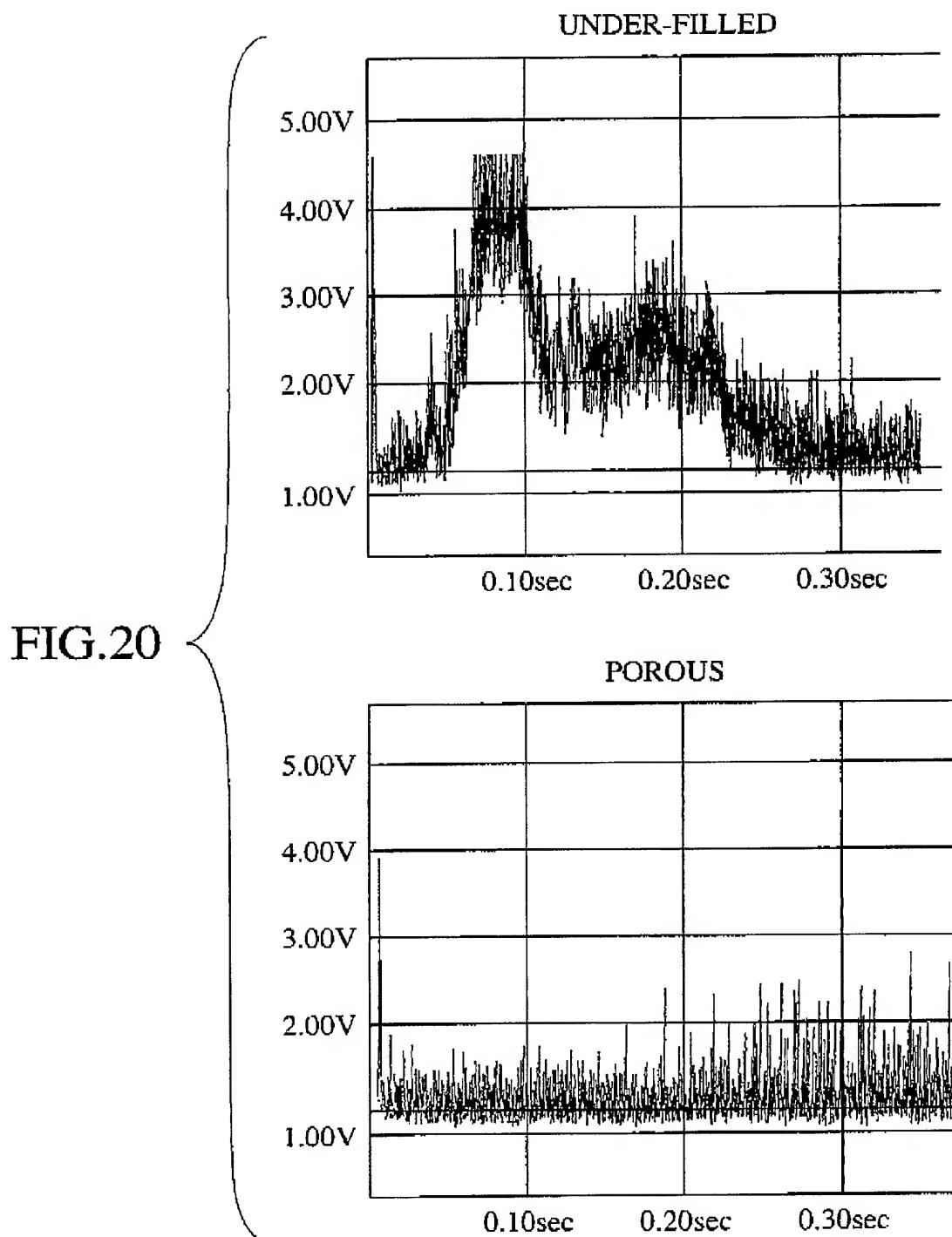
CONFORMING



NON-WELDED

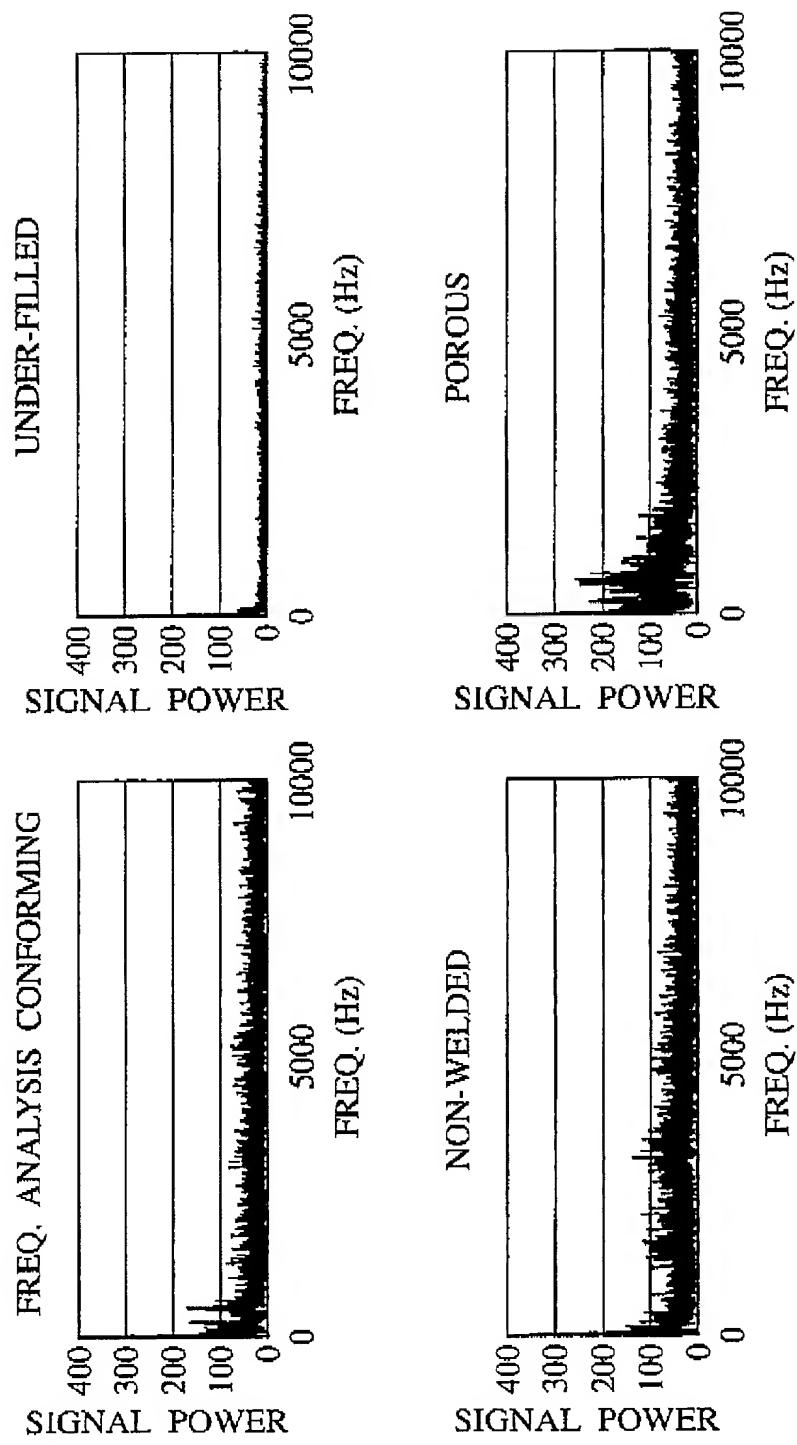


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FIG.21



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FIG.22

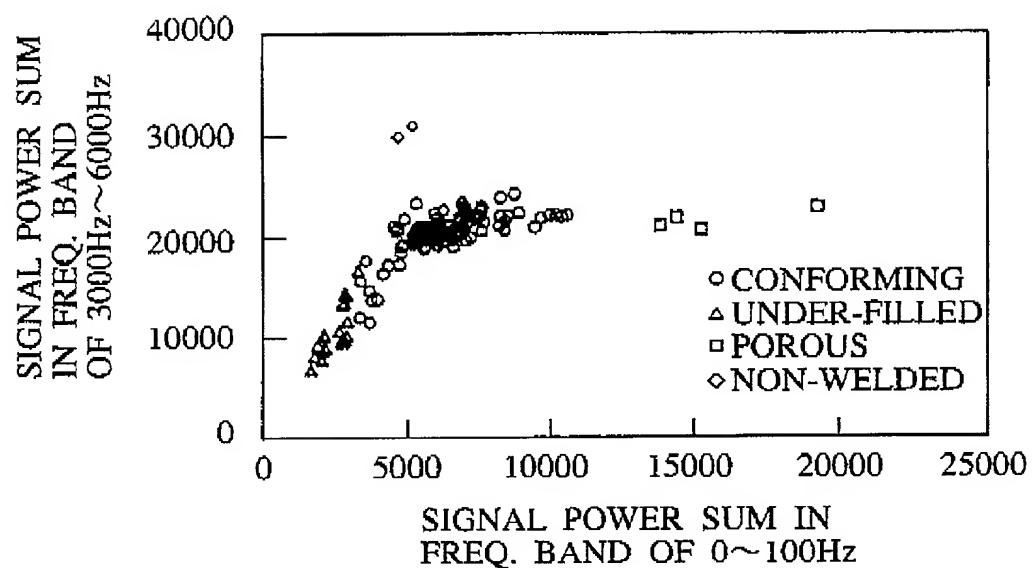
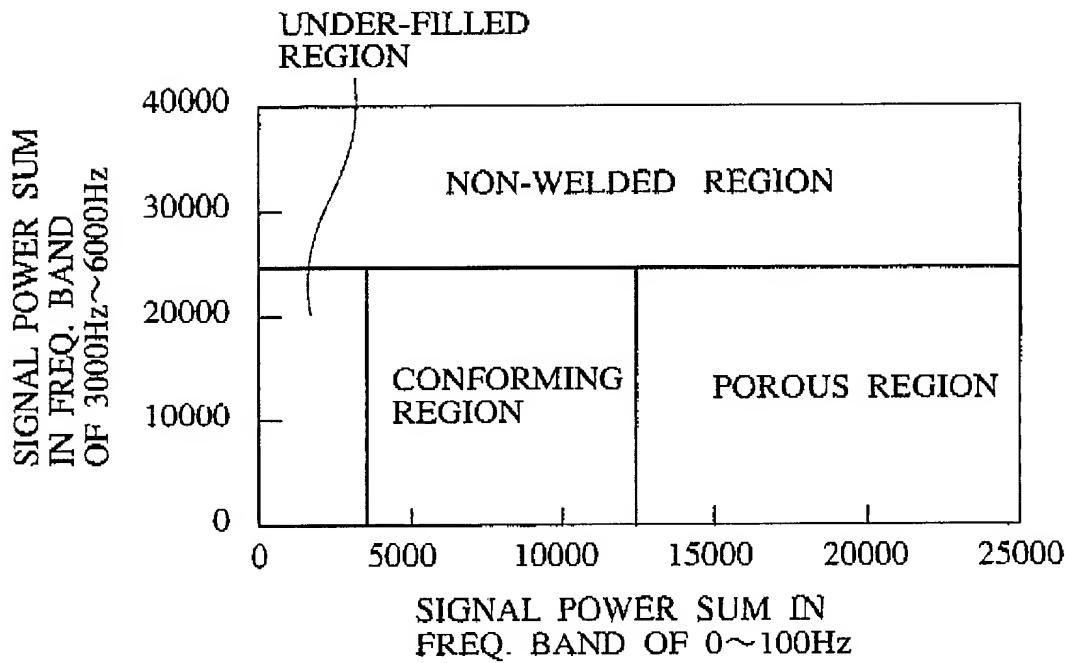


FIG.23



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FIG.24

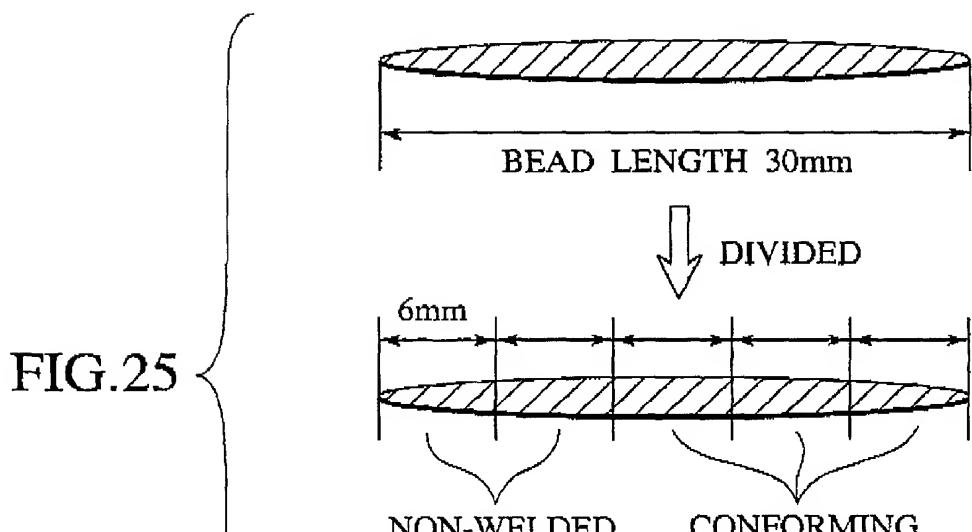
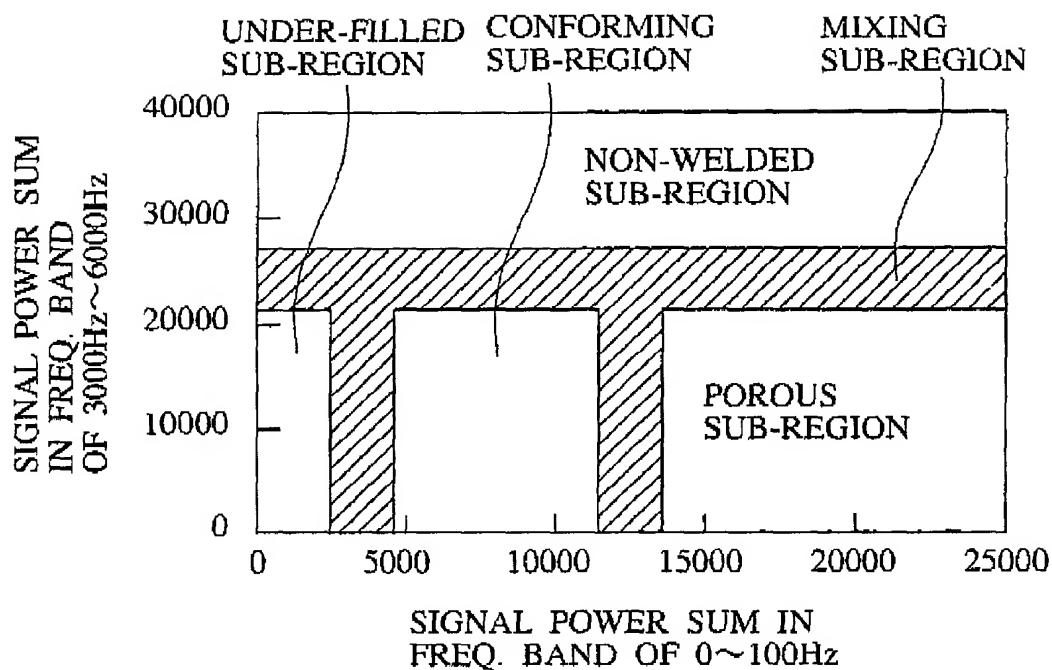


FIG.25

$$\text{CONFORMING PROPORTION} = \frac{\text{CONFORMING LENGTH } 6\text{mm} \times 3 \text{ SUB-SECTIONS}}{\text{TOTAL WELD LENGTH } 30\text{mm}} = 0.6$$

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FIG.26

